

D4883-7
Job Sheet 167186

Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada



DART
AEROSPACE

D4883-7
Job Sheet 167186

Part No: D4883-7

Status:
Job Tracking No:
Created By:
Description:

Part Weight: 0 lbs
Job Created: 10/26/11
Due Date: 10/27/11
Type: SOLD

Ship Via:

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Setup Run Hrs	Standard	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
90	Start up Operation	10 Ea	10/26/17	10/26/17	0.00	0.00	Start Up Machining		18-1-13 18/01/17 18/01/17 18/01/17 18/01/17 18/01/17 18/01/17 18/01/17 18/01/17 18/01/17
100	CNC Lathe	10 pcs	10/26/17	10/26/17	0.00	10.18	Doosan		
120	CNC Vertical Machining	10 pcs	10/27/17	10/27/17	0.00	10.18	HAAS 1		
140	QC	10 pcs	10/27/17	10/27/17	0.00	0.00	QC2		
140	QC	10 pcs	10/27/17	10/27/17	0.00	0.00	QC8		
150	Outsource	10 pcs	10/27/17	10/27/17	0.00	0.00	Outsource2		
160	Packaging	10 pcs	10/27/17	10/27/17	0.00	0.00	Packaging2		
190	QC	10 pcs	10/27/17	10/27/17	0.00	0.00	QC5		
200	Packaging	10 pcs	10/27/17	10/27/17	0.00	0.00	Packaging3		
210	QC21-SA	10 Ea	10/27/17	10/27/17	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Dwg. D4883-7 Turning Detail & Folio FB255. 2- USE DT10006 For sizing blanks.
 120 - 1-Machine as per Folio FB255 & Dwg D4883-7 END FITTING, deburr and Break all sharp edges.
 130 - QC2- Inspect parts off machine FAI/FAIB
 140 - QC8- Inspect parts - second check
 150 - Outsource process - NDT per QSI038 4.1 Issue P/O: _____ LPI Per ASTM
 Certificate of conformity is required.
 160 - Receive & inspect for Damage & Mat'l Certs Certificate of conformity is req'd.
 190 - QC5- Inspect part completeness to step on W/O
 200 - Identify as per dwg & Stock Location:
 210 - QC21- Final Inspection - Work Order Release

90-Start up Operation	M174PH-H900R2.000	2	Inventory	24	Allocated	0	Std Qty	0
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Part Specifications			
Spec No	Description	Target/Tolerance	Limits
1	End Fitting	0.500inches + 0.006	0.506
2	End Fitting	0.030inches ± 0.030	0.060
3	End Fitting	0.017inches ± 0.030	0.047
4	End Fitting	0.430inches ± 0.030	0.460
5	End Fitting	0.500inches ± 0.010	0.510

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ S003367 End Fitting PART NO: D4883-7 Revision: Operation: Start up Operation Quantity: 10 Change No:	DISPOSITION Rework ☐	Skid-tube ☐	Cross tube ☐ Fab ☐ ing ☐ site ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Mfg Date: 10/29/17 Job No: 167186			AGAINST DEPARTMENT/PROCESS MRB (QSI042) Approval ☐ Completed By _____ Lead hand / Supervisor Approval Verification ☐ QC / QA Coordinator Approval ☐		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

			0.490	
6	End Fitting	1.460Inches $\pm$ 0.030	1.490	
			1.430	
7	End Fitting	0.670Inches $\begin{matrix} + 0.000 \\ - 0.001 \end{matrix}$	0.670	
			0.669	
8	End Fitting	1.410Inches $\pm$ 0.030	1.440	
			1.380	
9	End Fitting	0.125Inches $\begin{matrix} + 0.004 \\ - 0.001 \end{matrix}$	0.129	
			0.124	
10	End Fitting	0.930Inches $\pm$ 0.030	0.960	
			0.900	
11	End Fitting	0.020Inches $\pm$ 0.010	0.030	
			0.010	
12	End Fitting	45.0Degrees $\pm$ 0.5	45.5	
			44.5	
13	End Fitting	0.063Inches $\pm$ 0.010	0.073	
			0.053	
14	End Fitting	0.300Inches $\pm$ 0.030	0.330	
			0.270	
15	End Fitting	0.130Inches $\pm$ 0.030	0.160	Radius
			0.100	
16	End Fitting	0.750Inches $\begin{matrix} + 0.030 \\ - 0.000 \end{matrix}$	0.780	
			0.750	
17	End Fitting	0.930Inches $\pm$ 0.030	0.960	
			0.900	
18	End Fitting	0.060Inches $\pm$ 0.030	0.090	Radius
			0.030	
19	End Fitting	1.633Inches $\pm$ 0.005	1.638	
			1.628	
20	End Fitting	2.790Inches $\pm$ 0.030	2.820	
			2.760	
21	End Fitting	0.090Inches $\pm$ 0.010	0.100	
			0.080	
22	End Fitting	0.750Inches $\pm$ 0.030	0.780	
			0.720	
23	End Fitting	0.249Inches $\pm$ 0.010	0.259	
			0.239	
24	End Fitting	0.380Inches $\pm$ 0.030	0.410	
			0.350	

Plex 10/26/17 8:35 AM dart.Michaud-Febrille.Victoria

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038831

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038831
PO Date: 1/22/18
Due Date: 1/25/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167186	D4883-7	End Fitting Outsource process - NDT per QSI038 4.1 Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required.	Firmed	1/25/18	10 pcs	0 pcs	10 pcs	\$55.1429/pcs	\$551.43
2	167164	D4885-3	End Fitting ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417	Firmed	1/25/18	8 pcs	0 pcs	8 pcs	\$55.1429/pcs	\$441.14
3	169544	D4464-041	Fuel Tank Assembly ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14
4	168063-C	D212-664-201	Aft Crosstube - High ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14
5	170235	D212-664-201	Aft Crosstube - High ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	1/25/18	1 pcs	0 pcs	1 pcs	\$55.1429/pcs	\$55.14
Grand Total:										\$1,158.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report

18/01/27 *me*

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34719	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038831
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

2 AFT CROSSTUBES, P/N# D212-664-201 , J/S# 168063-C, 170235 ✓

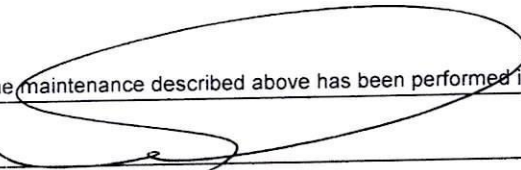
1 FUEL TANK ASSY, P/N# D4464-041 , J/S# 169544 ✓

8 END FITTING, P/N# D4885-3 , J/S# 167164 ✓

10 END FITTING, P/N# D4883-7 , J/S# 167186 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						JAN 23 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JAN 23 2018
Name: RAFIK MELIKIAN		